

Date: Wednesday, 4/5/2006 3:29:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 26563		Part Number	: D2574		
Estimate Number	: 10534		Drawing Number	: D2574 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/5/2006 S.O. No. : N/A		Drawing Revision	: E		
Prsht Rev.	: NC		Material	: A		
First Issue	: N/A		Due Date	: 4/24/2006		
Previous Run	: 26499		Qty:	4	Um:	Each
Written By	: See Comments Below					
Checked & Approved By	: KJ 06.04.06					
Comment	: Est Rev: I As Per RevE 06-01-27 JLM					

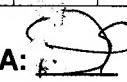
Additional Product

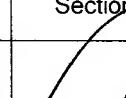
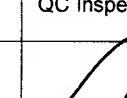
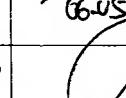
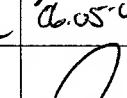
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B24069</u> <i>J-G/E 06105103 4</i>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>26563</u> Double check by: <i>SD</i> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. <i>J-G/E 06105103 4</i>		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574 <i>Eo 06105105 x4</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>J-G/E 06105105 x4</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/04	2/3	Dim. 'w' 0.125" is 0.106" offset on 4th Axis too low. (3rd opp) (1 point affected)	CP 06.05.04 QS1042	PART OK per DS email	ED 06/05/05	 66.05.04	CP 06.05.04 per QS1042	 06.05.04
06/05/04	2/3	Dim. 'w' 0.125" is 0.100" offset on 4th Axis too low (3rd opp) First Run	CP 06.05.04 QS1042	PART OK per DS email	ED 06/05/05	 66.05.04	CP 06.05.04 per QS1042	 06.05.04

NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:29:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 26563

Part Number: D2574

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	SA 06-05-08
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	SA 06-05-09 ④
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	FC 06-05-09 ④
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST480	AP 06/05/10 ④
10.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	DP 06/05/11 ④

Job Completion



u 06-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

IDART AEROSPACE LTD

Work Order: 26563

Description: Saddle, Aft Inboard

Part Number: D2574

Inspection Dwg: D2574 Rev. E

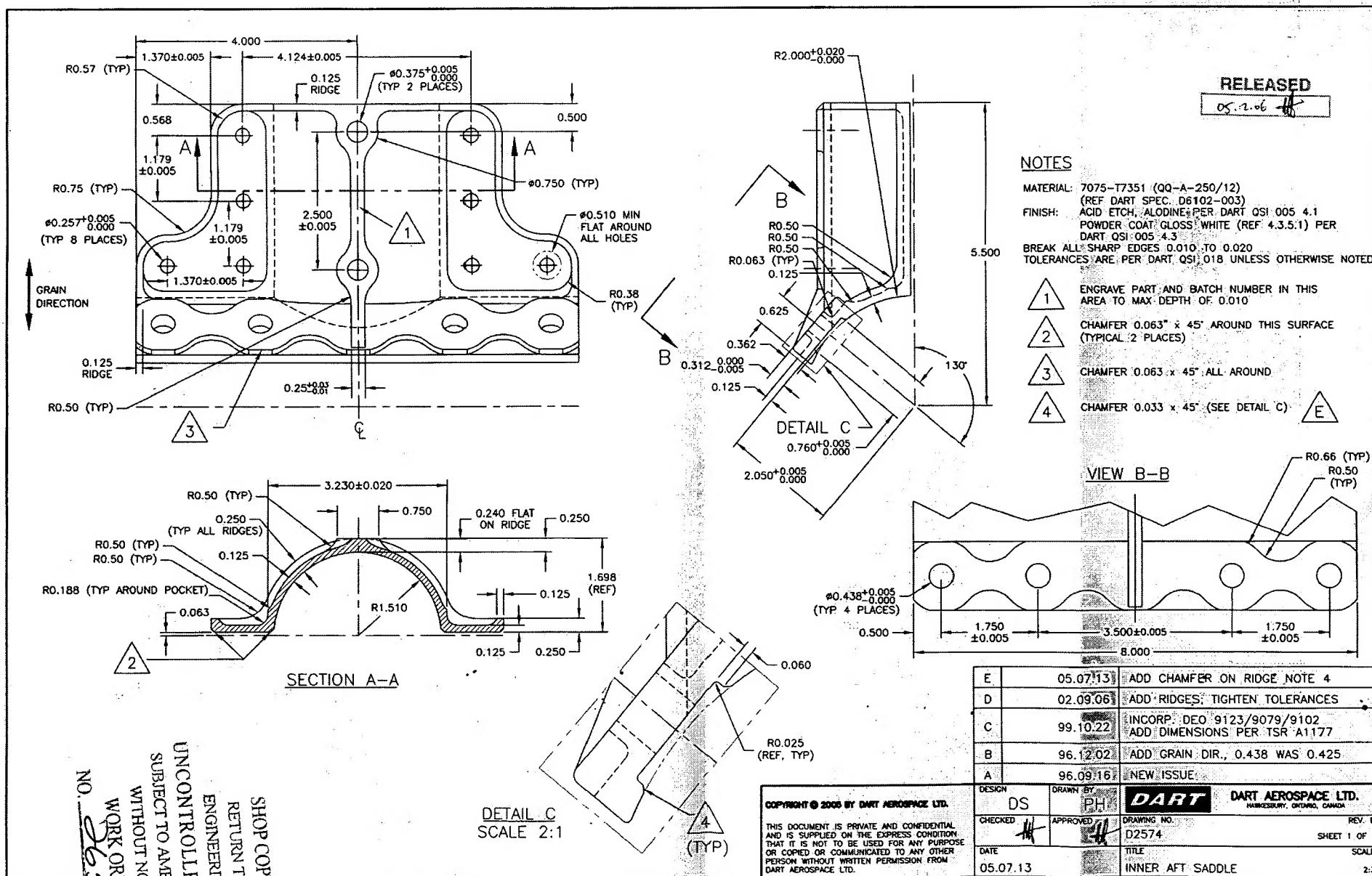
Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				
				See Attached E-mail	See Attached A/Anchored email	3	4	By
A	0.438	0.443	DT8682	0.440	0.438	0.438	0.438	
B	1.745	1.755		1.747	1.745	1.745	1.745	
C	3.495	3.505		3.498	3.498	3.497	3.497	
D	1.745	1.755		1.747	1.745	1.745	1.745	
E	7.990	8.010		8.005	8.006	8.005	8.005	
F	0.490	0.510		0.502	0.500	0.504	0.506	
G	0.257	0.262	DT8683	0.258	0.257	0.257	0.257	
H	0.375	0.380	DT8684	0.376	0.375	0.375	0.375	
I	0.490	0.510		0.498	0.498	0.499	0.498	
J	1.174	1.184		1.176	1.175	1.176	1.176	
K	0.558	0.578		0.569	0.564	0.564	0.569	
L	1.174	1.184		1.176	1.175	1.176	1.176	
M	1.365	1.375		1.368	1.367	1.368	1.368	
N	2.495	2.505		2.498	2.495	2.496	2.495	
O	4.119	4.129		4.119	4.119	4.119	4.120	
P	0.115	0.135		0.117	0.119	0.118	0.118	
Q	0.115	0.135		0.130	0.135	0.135	0.135	
R	0.240	0.260		0.243	0.250	0.248	0.249	
S	0.115	0.135		0.119	0.117	0.118	0.115	
T	0.178	0.198		0.188	0.188	0.189	0.188	
U	3.210	3.250		3.230	3.233	3.230	3.230	
V	0.230	0.250		0.232	0.230	0.230	0.230	
W	0.115	0.135		0.115	0.106	0.124	0.124	
X	0.307	0.312		0.309	0.310	0.309	0.310	
Y	0.760	0.765		0.765	0.765	0.765	0.765	
Z	0.352	0.372		0.362	0.370	0.370	0.366	
AA	0.470	0.530		0.500	0.500	0.500	0.500	
AB	0.615	0.635		0.620	0.620	0.620	0.624	
AC	0.053	0.073		0.063	0.063	0.063	0.063	
AD	0.240	0.260		0.243	0.241	0.244	0.242	
AE	1.500	1.520		1.508	1.511	1.512	1.513	
AF	0.115	0.135		0.132	0.135	0.135	0.135	
AG	0.240	0.280		0.265	0.260	0.260	0.260	
AH	0.240	0.260		0.244	0.240	0.241	0.242	
AI	2.000	2.020		N/A	N/A	N/A	N/A	
AJ	0.023	0.043		0.033	0.030	0.030	0.030	
Accept/Reject								

Measured by: J. G / *Sp*
Date: 06/05/03Audited by: J.L
Date: 06/05/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JL</i> <i>JL</i>	



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Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: May 4, 2006 4:45 PM
To: Chris Provencal
Subject: Re: NCR for D2574 saddle

Chris

For the reasons you have outlined below, I believe these saddles are acceptable.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Thursday, May 04, 2006 2:36 PM
Subject: NCR for D2574 saddle

> David,
>
> Two D2574 Saddles, thickness of saddle wall on skidtube should be 0.125.
On
> one it is 0.110", on another it's 0.106". Is this acceptable?
>
>
> If it were the outside saddle, I would be keen on scrapping it, but
because
> its the inner saddle, that wall covers such a small area, I'm not sure if
> its that significant?!?
>
> I attached a picture to show what dimension is affected
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email...cprovencal@dartaero.com
> Phone...613-632-3336
> Fax.....613-632-4443
>